

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000504**Date Inspected:** 31-Aug-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1430**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2230**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** CWI/QC Xu Lefeng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** 77m Mock-Up**Summary of Items Observed:**

On this date, Caltrans Office of Structural Materials (OSM), Quality Assurance (QA) Inspector, David A. Smith was present for the random observations related to the following;

Item-1 Sub Assembly-104 Joint 73. Filler welding continues utilizing Lincolnweld LA-85 wire, stock #ED032197, QC Lot #826M & 3/16" diameter or 4.8mm. The welding operator was Cao Xiao Hau #056975. The recorded Amps was 632 & Volts 31.3 welding travel speed was 384.7 mm/min. Said to be complete with the welding by 9-1-2007 AM.

Item-2 Sub Assembly-95 Joint 73. Same welding wire as Item-1 Amps was 641 & Volts 29.9 with a weld travel speed of 379 mm/min. The welding operator was Xie Yonglin #048882. Welding said to be complete during the morning of 9-1-2007.

Item-3 Skin Plate-A, Stiffener Plate #4. Preheating is now in progress for the welding of the root.

Item-4 Skin Plate-C. Tack welding has been completed and the back gouged area is being ground down and dressed prior to performing the required magnetic particle testing.

Item-5 Skin Plate-D, Stiffener Plate 3. Preheating for the filler welding now in progress.

**Summary of Conversations:**

There were no pertinent conversations pertaining to the project during this shift.

**Comments**

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

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## WELDING INSPECTION REPORT

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<b>Inspected By:</b>	Smith,David	Quality Assurance Inspector
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<b>Reviewed By:</b>	Cochran,Jim	QA Reviewer
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